

Work Order ID 67860

Friday, April 01, 2011 12:42:16 PM



Page 1

Item ID: D3953-7

Accept



Setup Start



Revision ID:

Item Name: Spring Spacer

Stop



Start Date: 4/1/2011 Start Qty: 12.00



Required Date: 4/8/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3953

C

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA854 & DWG

FOLIO REV: N/A

DWG REV: C

DEBURR

110414

12

φ

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

110414

12

φ

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Page 2

Item ID: D3953-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Spring Spacer

Start Date: 4/1/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

K.A 11/04/04

12

φ

130

Identify as per dwg & Stock Location: 96

0.00



Packaging

Memo

0.00

Packaging

11/4/04 (120)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/05

ME

11-04-05

Picklist Print

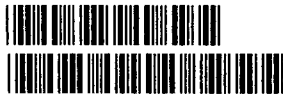
Friday, April 01, 2011 12:42:14 PM

Page 1

Work Order ID: 67860

Parent Item: D3953-7

Parent Item Name: Spring Spacer



Start Date: 4/1/2011

Required Date: 4/8/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750		Purchased	No			100	f	119.0000	0.05	0.631579			



Delrin Round Bar 0.75"



11/21/11

Location

Loc Qty

Loc Code

MAT055

119

115472

34

116183

5

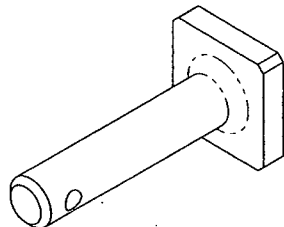
117273

80

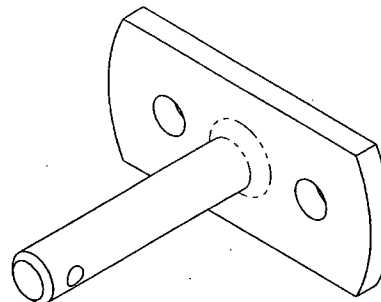
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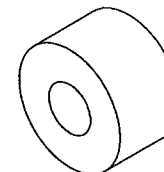
D3953-1 GAS SPRING BRACKET
(FULL LID)



D3953-3 GAS SPRING STUD, LID



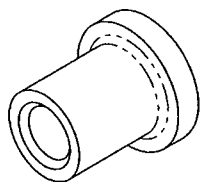
D3953-5 GAS SPRING STUD, BASE



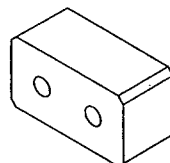
D3953-7 GAS SPRING SPACER



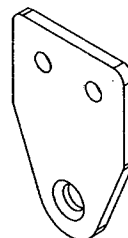
D3953-9 GAS SPRING WASHER



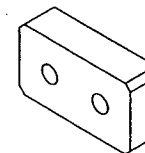
D3953-11 GAS SPRING SPACER



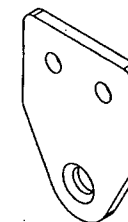
D3953-13 GAS SPRING SPACER
(FULL LID)



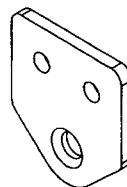
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)

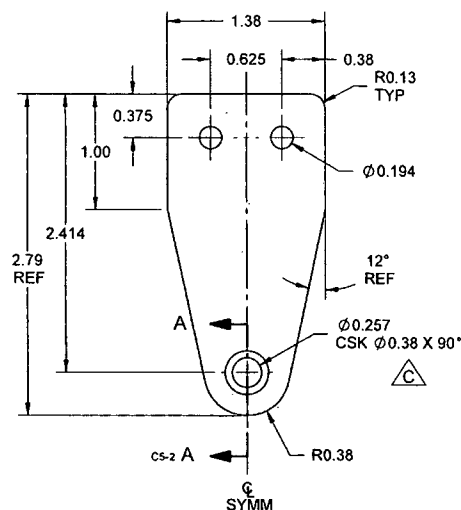


D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

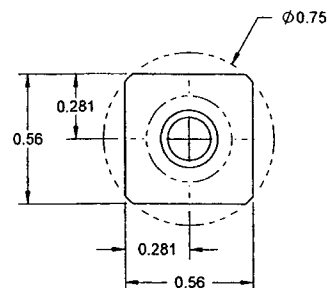
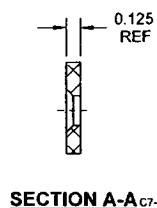
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R 2010-02-26

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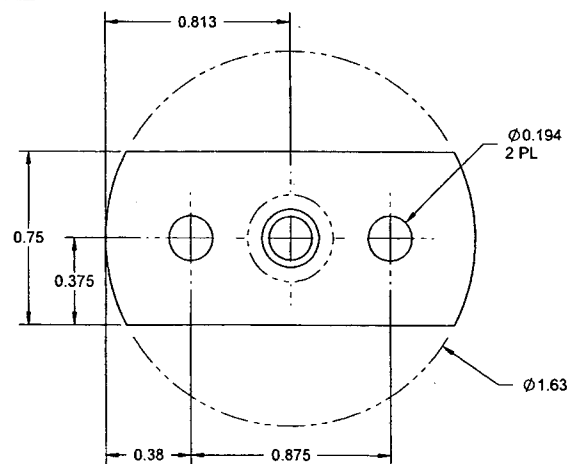
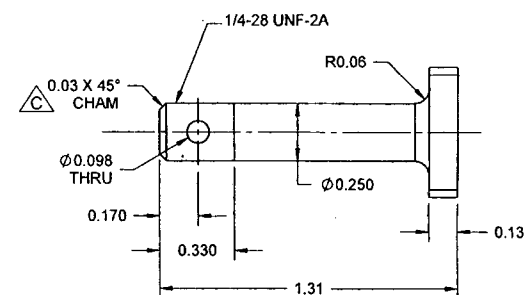
C	PARTS -19 & -21 ADDED (SHT 1 & 4): CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); C SYMM WAS C SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD, DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED, REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>JP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JP</i>	D3953	SHEET 1 OF 4
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	<small>* COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3953-1 GAS SPRING BRACKET
(FULL LID)



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE

NOTES:

1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

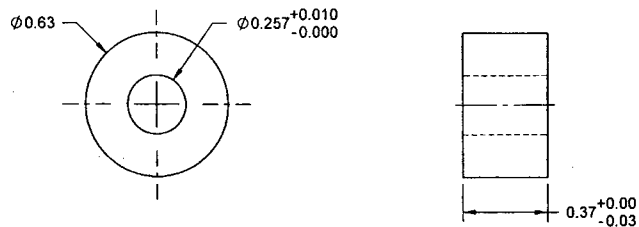
-3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
OR:
AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -1: 0.11 lbs
-3: 0.03 lbs
-5: 0.06 lbs

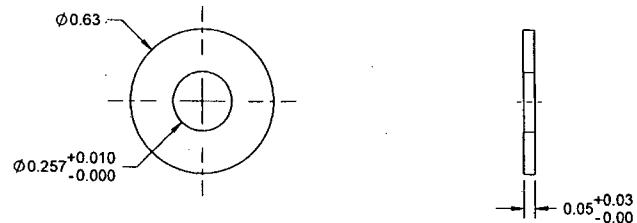
67860

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MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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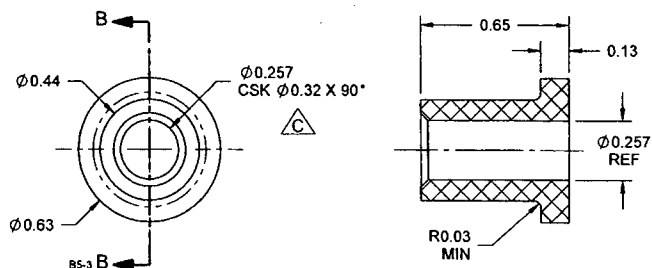
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2010-07-26



D3953-7 GAS SPRING SPACER

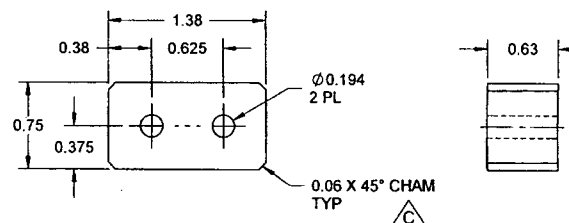


D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER

SECTION B-B B7-3



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELIRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

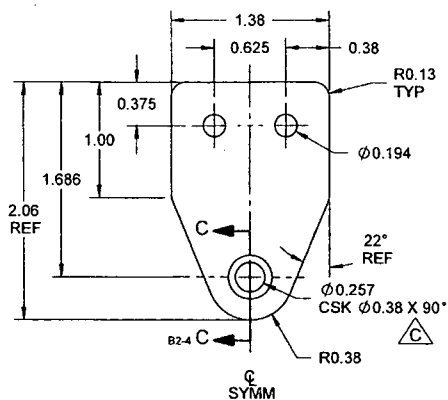
6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

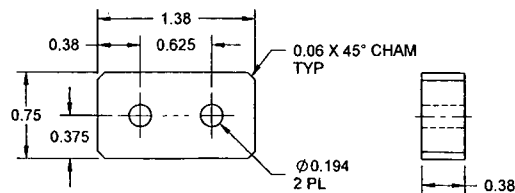
-13: 0.17 lbs

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2010-02-26

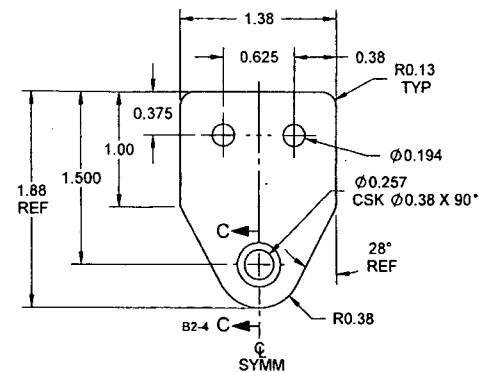
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DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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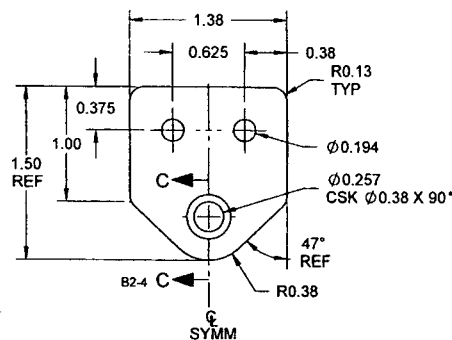
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



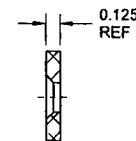
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)



SECTION C-C

NOTES:

1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -15: 0.08 lbs

-17: 0.10 lbs

-19: 0.07 lbs

-21: 0.06 lbs

RELEASED
2010-02-26

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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